DuPont Automotive Finishes

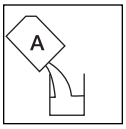
DuPont™ Plas-Stick® 2322S™ Adhesion Promoter for Plastics

Description

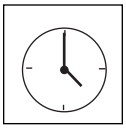
Plas-Stick® 2322S™ is an adhesion promoter for polyolefin or unidentified unprimed automotive plastics.
When combined with proper surface preparation, this product enhances the performance of ChromaSystem™ products on unprimed polyolefin plastic parts. Plas-Stick® 2322S™ must be primed or sealed prior to topcoating.
Note: For collision market use, Plas-Stick® 2322S™ is being replaced by Plas-Stick® 2330S™ Plastics Adhesion Promoter. Refer to Plas-Stick® 2330S™ (and Plas-Stick® 2320S™ Plastics Cleaner) technical data sheets for the most current plastic repair recommendations.

General Information

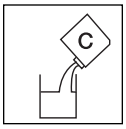
Components
Plas-Stick® 2322S™ Adhesion Promoter for Plastics



Mix Ratio/Viscosity
Ready-to-spray.



Pot Life
Indefinite.



Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Flattener:	Not recommended.
Flex Additive:	Not recommended.
Reducer:	Not recommended.
Retarder:	Not recommended.

Tinting:
Not recommended.

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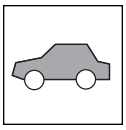
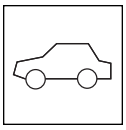


Primer/Sealer
Plas-Stick® 2340S™ Flexible Adhesion Sealer
DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler (for rigid plastics only)
DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler with Plas-Stick® 2350S™ Flexible Additive
DuPont™ URO® 1120S™/1140S™ Primer-Filler (for rigid plastics only)
DuPont™ URO® 1120S™/1140S™ Primer-Filler with Plas-Stick® 2350S™ Flexible Additive
DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4150S™ Flex-Additive
DuPont 4904S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ Flex-Additive
DuPont 4810S™/4840S™/4870S™ 2K UltraProductive Primer-Sealer with Plas-Stick® 4150S™ Flex-Additive
DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer with Plas-Stick® 4950S™ Flex-Additive
ChromaFil® 4140S™(for rigid plastics only)
ChromaPremier® 42410S™/42440S™/42470S™ Sealer (for rigid plastics only)
ChromaPremier® Sealer with Plas-Stick® 2350S™ Flexible Additive
Low VOC Prime 'N Seal® 4710S™/4740S™/4770S™ (for rigid plastics only)
Note: Always apply one of the preceeding Primers/Sealers over Plas-Stick® 2322S™.Adhesion Promoter for Plastics.

Application



Substrates
Unprimed rigid, semi-rigid, or flexible automotive polyolefin or unidentified plastic parts
Note: Since it is difficult for paint to adhere to polyethylene and polyproplylene, clean and sand thoroughly before applying Plas-Stick® 2322S™ or Plas-Stick® 2330S™.
Note: Do not use Plas-Stick® 2322S™ over fiberglass, silicone rubber, polyurethane foams, or primed plastics.

Flexible plastics that have been properly prepared. See "DuPont Flexible Plastics Repair Procedures Flow Chart" for schematic representation.

Types of Plastic Substrates and how to Paint them:

Type 1: Painting Raw Plastic Parts

Surface Preparation and Painting
All plastic substrates must be thoroughly cleaned and sanded as described below to ensure adequate cleaning (See Flexible Plastics Repair Flow Chart for process summary):

■ **Step 1:** Clean surface with mild detergent and hot water.

■ **Step 2**: Saturate the plastic with Plas-Stick® 2320S™ and continue to apply Plas-Stick® 2320S™ while rubbing wet surface with a clean cloth. After 4-5 min., the surface should have no gloss and it should not feel slick. If it does, reapply Plas-Stick® 2320S™ as described above and continue until gloss is reduced and the surface is not slick. **It is crucial to clean the surface as described to get good adhesion.**

■ **Step 3:** Sand substrate thoroughly using the grit described:

Hand sanding: Use gray Scotchbrite (or 800 grit sandpaper). Do not use 320 grit or red Scotchbrite, it is too severe and will rip the plastic substrate surface.

DA sanding: Use 500 grit (Do not use 320 grit, it is too severe)

■ **Step 4:** Clean again with Plas-Stick® 2320S™ as described in Step 2. And repeat until substrate is squeaky clean. To minimize static build-up allow 2320S™ to flash dry after cleaning.

■ **Step 5**: Apply two medium coats of Plas-Stick® 2322S™** **immediately after cleaning with Plas-Stick® 2320S™ to guarantee adhesion.**

(For fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use Plas-Stick® 2322S™.)**

■ **Step 6.** Allow Plas-Stick® 2322S™ to dry 20 min before applying sealer (e.g., ChromaPremier® Sealer)

■ **Step 7. Apply activated basecoat.**

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■ **Step 8.** Apply clearcoat with Plas-Stick® 2350S™Flexible Additive. **Note:** For ChromaClear® 4500S™, 4700S™, G2-4500S™, G2-4700S™, and 7900S™, and ChromaPremier 72200S™ 72400S™ and 72500S™ Clearcoats, simply add 2 oz Plas-Stick® 2350S™ per ready-to-spray quart of activated clearcoat.

Tips for Success

■ *For difficult-to-clean and textured plastics, temper the substrate for 30 minutes at 140°F (60°C) after cleaning and sanding. This may be helpful in driving out further mold release agents. Do not sand after tempering. Reapply* Plas-Stick® *2320S™ after tempering to remove mold release agent.*

■ *Use a clean cloth when applying* Plas-Stick® *2320S™.*

Type 2: Painting Pre-Primed Plastic Parts *(where* ***primer swells*** *when applying solvent.... remove it before you paint)*

When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting occurs. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in ***Steps 1 and 2****.*

Surface Preparation and Painting

■ ***Step 1****: Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes*. After the solvent has flashed, wipe off primer from areas that lifted.*
[*Caution: *Be careful when using Basemaker® 7175S™. Avoid static buildup due to potential risk of flash fire].*

■ ***Step 2****: Repeat Step 1 to make sure all of the solvent sensitive primer has been removed.*

■ **Step 3**: Go to **Type 1: Painting Raw Plastic Parts** (previous page) and follow steps 1 to 8 for the remainder of the repair.

Type 3: Painting Pre-Primed Plastic Parts *(If* ***primer is resistant to solvent****, sand primer and paint)*

When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting occurs. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in Step 1. If no swelling or lifting occurs proceed to Step 2.

■ ***Step 1****: Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes. If the primer does not lift anywhere on the bumper, proceed to Step 2.*

■ ***Step 2****: Sand substrate with 400 or 500 grit sandpaper. Be careful not to sand through the primer.*

■ ***Step 3****: Clean with DuPont Final Klean 3901S™ or DuPont Low VOC Final Klean 3909S™ and let dry.*

■ **Step 4**: Go to **Type 1: Painting Raw Plastic Parts** and follow steps 6 to 8 for the remainder of the repair.

■ *Aside: If cut-throughs occur, complete the surface prep procedure and use Plas-Stick® 2330S™ (over the cut-through only) to promote good adhesion.*

Caution: Do not use solvent-based cleaners on unprimed plastic or fiberglass (i.e., DuPont First Klean 3900S™, DuPont Final Klean 3901S™, Prep-Sol® 3919S™, DuPont 3939S™ Lacquer & Enamel Cleaner) due to static buildup and the potential for flash fire.

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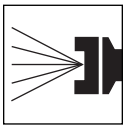
Gun Setups*

Conventional

Siphon Feed:	1.4 mm - 1.6 mm (.055” - .063”)
Gravity Feed:	1.3 mm - 1.5 mm (.051” - .059”)

HVLP

Siphon Feed:	1.4 mm - 1.6 mm (.055” - .063”)
Gravity Feed:	1.3 mm - 1.5 mm (.051” - .059”)



Air Pressure*

Conventional

Siphon Feed:	35 - 40 psi @ the gun.
Gravity Feed:	30 - 35 psi @ the gun.
HVLP	6 - 8 psi @ the gun cap.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers’ equipment, see the Appendix section titled “Equipment Information.”

Application

Apply 2 light to medium coats. Follow with the appropriate primer or sealer.

Flash/Dry Times

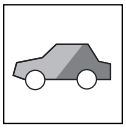
Air Dry

Flash between Coats:	5 minutes.
Time to Prime/Seal:	15 minutes.

Note: Plas-Stick® 2322S™ must be primed or sealed within 2 hours to minimize the potential for contamination and to ensure proper adhesion.

Blending

Plas-Stick® 2322S™ may be used for spot repairs.

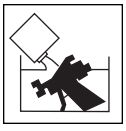


Recoatability/Re-repair

Plas-Stick® 2322S™ may be recoated with itself at any stage of dry or cure. Avoid excessive film build.

Sanding

Plas-Stick® 2322S™ does not require sanding. If sanding is necessary, reapply Plas-Stick® 2322S™. Avoid excessive film build.



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

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Physical Properties

VOC: 6.6 lbs/gal ready-to-spray.
Theoretical Coverage: 140 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids: 10.5% ready-to-spray.
Volume Solids: 8.7% ready-to-spray.
Recommended Dry Film Thickness: .25 - .50 mils in 2 coats.
Flash Point: See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

Before using any DuPont Refinish product, be sure to read all safety directions and warnings. WEAR A PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.